

# Work Order ID 75567

Tuesday, October 25, 2011 2:00:56 PM

**\*75567\***

*Ship halloween*

Page 1

Item ID: D3137-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Bracket Assembly  
 Start Date: 10/25/2011 Start Qty: 2.00 **\*2\*** Cust Item ID:  
 Required Date: 10/28/2011 Req'd Qty: 2.00 **\*2\*** Customer:  
 Reference:

Approvals: Process Plan: mf Date: 11-10-25 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3137	Rev F								
100		0.00							
<b>*100*</b>									
Small Fab	Memo	0.00							
Small Fab	assemble as per dwg								
110	QC5- Inspect part completeness to step on W/O	0.00							
<b>*110*</b>									
QC	Memo	0.00							
Quality Control									
120	Identify as per dwg & Stock Location: <u>87 235B</u>	0.00							
<b>*120*</b>									
Packaging	Memo	0.00							
Packaging									

*EB 11/10/31 (2)*

*Sp 11/10/31*

*(2)*

*Sp 11-10-31*

**\*75567\***

Page 2

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Cust Item ID:**

\*2\*

\*2\*

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop **\*NR2\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

### Operation Description

### Set Up/ Run Hours

## Tool ID

**Tool #**Plan  
Code

**Accept  
Qty**

Reject  
QtyReject  
Number

**Insp.  
Stamp**

130

QC21- Final Inspection - Work Order Release

0.00

**\*130\***

QC

## Memo

0.00

## Quality Control

MF 11-40-31

# Picklist Print

Tuesday, October 25, 2011 2:00:56 PM

Page 1

Work Order ID: 75567

Parent Item: D3137-041

Parent Item Name: Bracket Assembly

Start Date: 10/25/2011

Required Date: 10/28/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 11.10.04 new issue DD verified by:EC

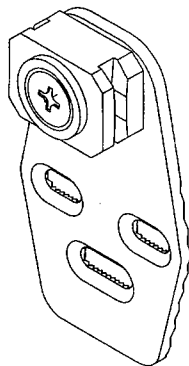
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3137-1 Bracket		Manufactured	No			100	Each	5.0000	1	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MEZZ		5							
				18659		5							
D3137-3 Guide		Manufactured	No			100	Each	3.0000	1	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST235B		3							
				73471		3							
D3137-5 Washer		Manufactured	No			100	Each	8.0000	1	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST235B		8							
				68262		8							
MS24694-S101 Screw		Purchased	No			100	Each	19.0000	1	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST289A		19							
				110363		9							
				118159		10							

MF 11-10-28

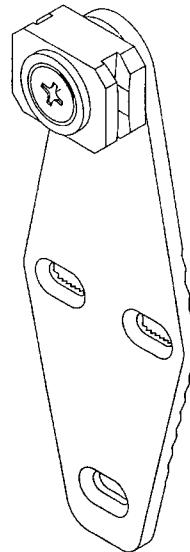
MF 11-10-28

MF 11-10-28

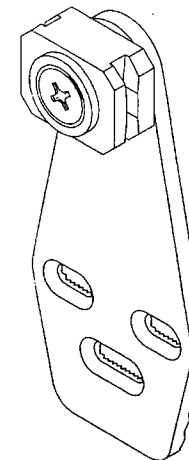
MF 11-10-28



**D3137-041 BRACKET ASSEMBLY**



**D3137-043 BRACKET ASSEMBLY**



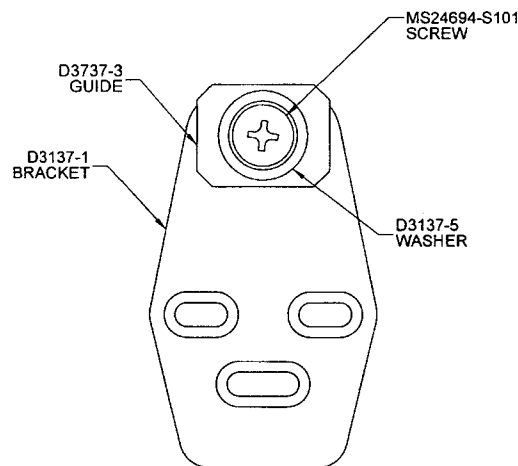
**D3137-045 BRACKET ASSEMBLY**

# 75507

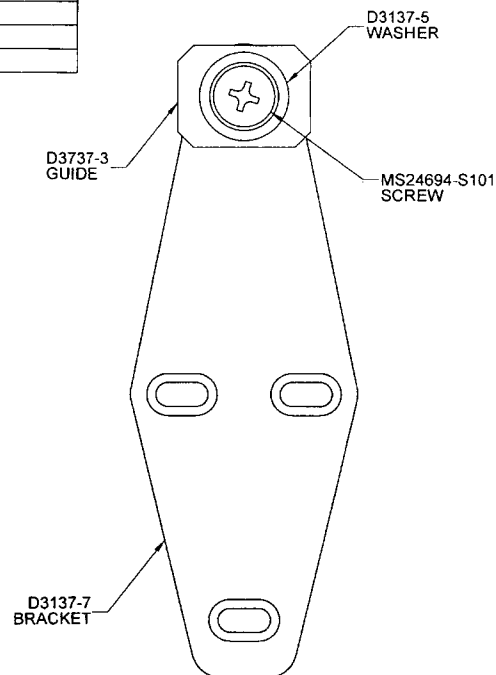
**RELEASED**  
08.06.26/17

F	REDRAWN & REFORMATTED IN SOLIDWORKS. SHEET 3 ZONE A.5 DIM 2.36 WAS 2.48, ZONE A.4 0.480 DIM WAS 0.505, ZONE A.3 0.67 DIM WAS 0.79, ZONE B.5 4.850 DIM WAS 4.975 & ZONE B.8 5.29 DIM WAS 5.41. REASON: PART TRIMMED DUE TO INTERFERENCE WITH EXECUTIVE INTERIOR.	AJS	08.05.30
E	ADD -045	RF	05.11.23
D	RE-DESIGN D3137-5; CHANGE DIMS	DS	04.11.03
C	ADD -043	DS	03.08.15
B	ADD RIDGES; ADD MATERIAL PROP	DS	03.01.16
A	NEW ISSUE	DS	02.04.17
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3137	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		<b>BRACKET ASSEMBLY</b>	NTS
DATE	08.05.30	<small>COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

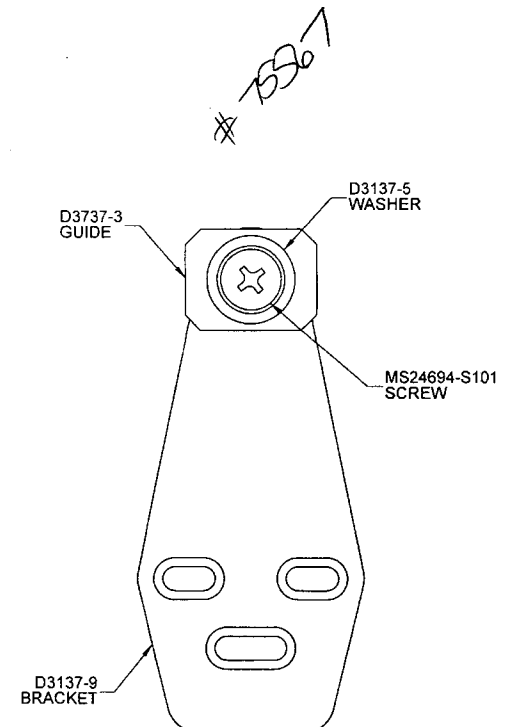
QTY. -041	QTY. -043	QTY. -045	PART NUMBER	DESCRIPTION
X			D3137-041	BRACKET ASSEMBLY
	X		D3137-043	BRACKET ASSEMBLY
		X	D3137-045	BRACKET ASSEMBLY
1			D3137-1	BRACKET
1	1	1	D3137-3	GUIDE
1	1	1	D3137-5	WASHER
	1		D3137-7	BRACKET
		1	D3137-9	BRACKET
1	1	1	MS24694-S101	SCREW



**D3137-041 BRACKET ASSEMBLY**



**D3137-043 BRACKET ASSEMBLY**

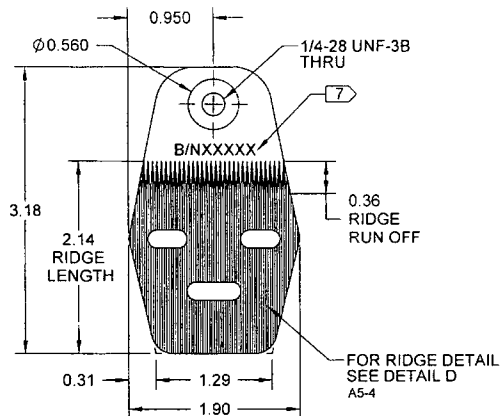


**D3137-045 BRACKET ASSEMBLY**

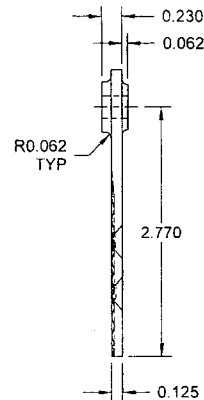
- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.18 lbs -041  
: 0.32 lbs -043  
: 0.27 lbs -045

RELEASED  
08.06.16

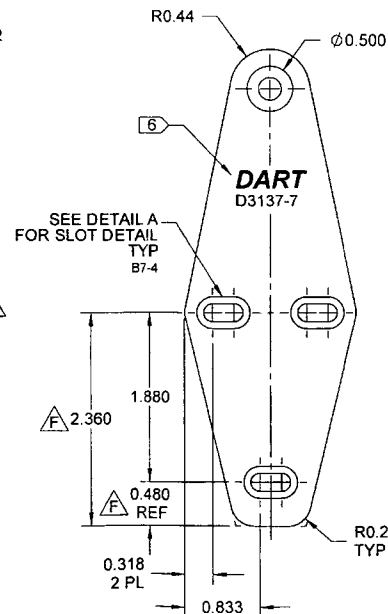
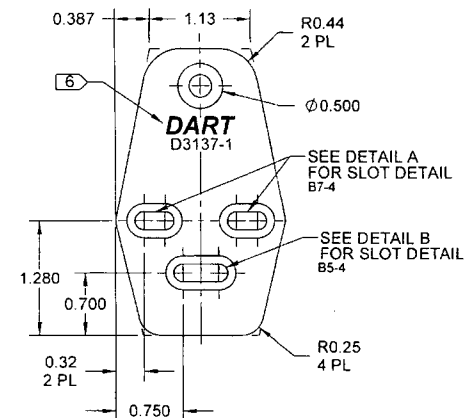
DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3137	SHEET 2 OF 5
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**D3137-1 BRACKET**






**D3137-7 BRACKET**

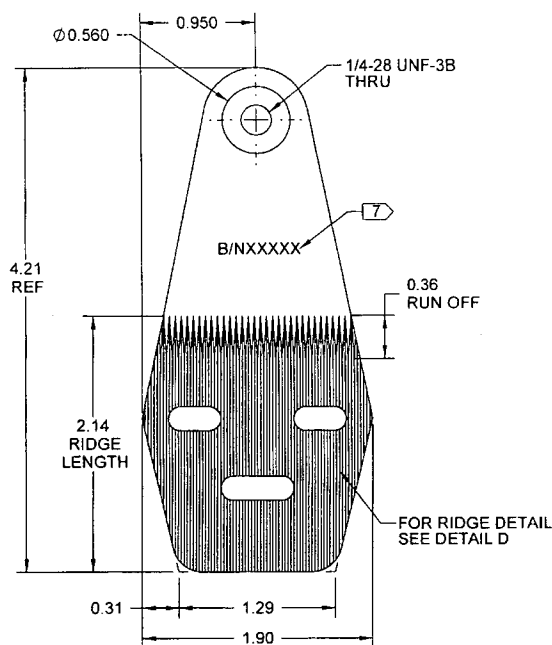


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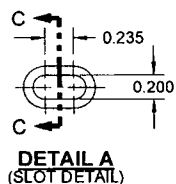
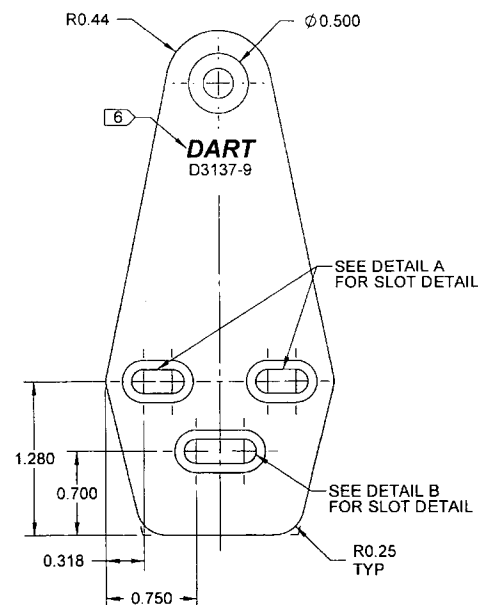
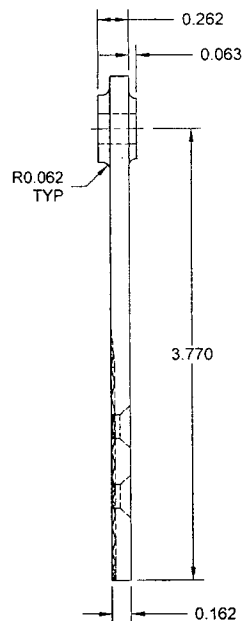
- 1) MATERIAL: -1 & -7  
17-4PH STAINLESS STEEL  
PER AMS 5604 OR 5643  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi  
PER DART SPEC. M17-4-B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: ENGRAVE DART LOGO USING 0.20 HIGH LETTERS & P/N WITH USING .15 HIGH LETTERS TO A MAX. DEPTH OF 0.010.
- 7) SCRIBE WITH DART B/N USING VIBRATING STYLUS
- 8) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
- 9) -1 REPLACES PREMIER P/N B30-23000-105/-1

**RELEASED**  
05-06-26

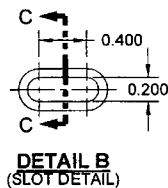
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DRAWN	A/S	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3137	SHEET 3 OF 5
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DE APPR.		BRACKET ASSEMBLY	NTS
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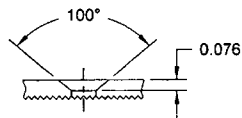
**D3137-9 BRACKET**



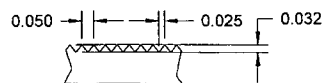
**DETAIL A**  
(SLOT DETAIL)



**DETAIL B**  
(SLOT DETAIL)




**SECTION C-C**  
(SLOT DETAIL)



**DETAIL D**  
SCALE 2X  
(TYPICAL RIDGE DETAIL)

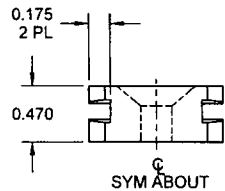
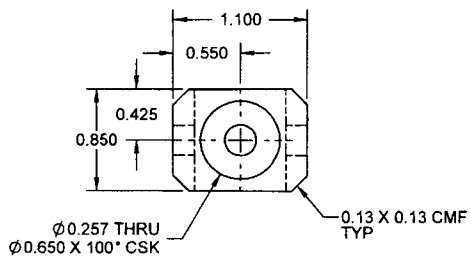
**NOTES:**

- 1) MATERIAL: 17-4PH STAINLESS STEEL  
PER AMS 5604 OR 5643  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi  
PER DART SPEC. M17-4-B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: ENGRAVE DART LOGO USING 0.20 HIGH LETTERS & P/N WITH USING .15 HIGH LETTERS TO A MAX. DEPTH OF 0.010.
- 7) SCRIBE WITH DART B/N USING VIBRATING STYLUS
- 8) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
- 9) REPLACES PREMIER P/N B30-23000-105/-106

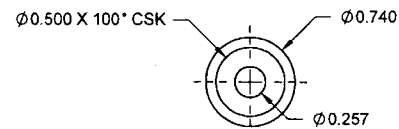
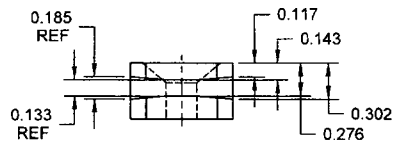
DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
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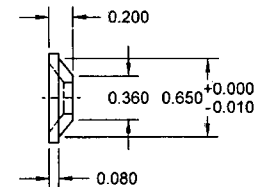
75307



**D3137-3 GUIDE**



**D3137-5 WASHER**



**NOTES:**

- 1) MATERIAL: -3  
DELIN II 150E OR ACETRON GP ACETAL, BAR  
(REF DART SPEC M-DELIN-B)  
-5  
6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) ALUMINUM BAR  
PER-AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4145/ 4116)  
OR PER-QQ-A-200/8 (OR AMS 4160)  
REF. DART SPEC M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 (-5 ONLY)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
- 8) -3 REPLACES PREMIER P/N B30-2300-207  
-5 REPLACES PREMIER P/N B30-2300-209

**RELEASED**  
880702/14

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3137	SHEET 5 OF 5
APPROVED		TITLE	SCALE
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